

Date: Thursday, 3/2/2006 3:07:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 26036		
Estimate Number	: 10349		
P.O. Number	: <i>N/A</i>	Part Number	: D28582
This Issue	: 3/2/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2858 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 24504	Drawing Revision	: B
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 3/22/2006
Checked & Approved By	: <i>06.03.02</i>	Qty:	24 Um: Each
Comment	: Est C 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s) ✓
 Material: 1.50" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B15001250
 Batch *M100384*

J.L 06.04.02

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

J.L 06.04.02 8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2858-2

J.L 06.04.02 24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.04.02 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 26/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

JL 06.04.02 (24)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

DL 06/04/06 (24)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JL 06.04.06 (24)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

DL 06/04/06 (24)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/04/10 (24)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST391

AL 06/04/10 (24)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/04/10 (24)

Job Completion



u 06/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26036
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.174	✓			
Ø0.400	+0.005/-0.000	.400	✓			
R0.125	+/-0.010	.125	✓			
0.328	+/-0.010	.328	✓			
0.820	+/-0.005	.820	✓			
1.476	+/-0.010	1.477	✓			
0.342	+/-0.010	.342	✓			
0.875	+/-0.010	.875	✓			
1.56	+/-0.030	1.562	✓			
0.147	+/-0.010	.148	✓			
0.717	+/-0.010	.723	✓			
0.697	+/-0.010	.695	✓			
0.229	+/-0.010	.229	✓			
R0.125	+/-0.010	1.125	✓			
R0.063	+/-0.010	1.063	✓			
0.063	+/-0.010	.065	✓			
0.126	+/-0.010	.129	✓			
0.630	+/-0.010	.630	✓			
R0.354	+/-0.010	1.354	✓			
0.965	+/-0.010	.968	✓			
Ø0.166	+0.005/-0.000	.169	✓			

Measured by: J.L	Audited by: JML	Prototype Approval:	N/A
Date: 06-04-02	Date: 06/04/02	Date:	N/A

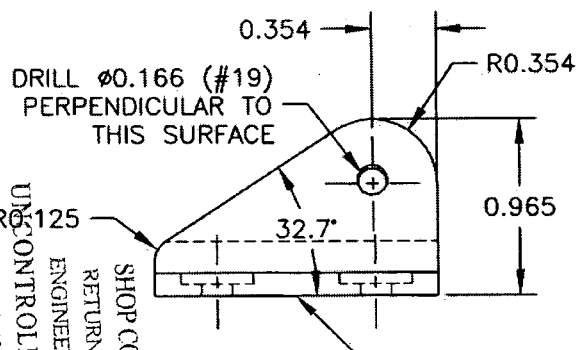
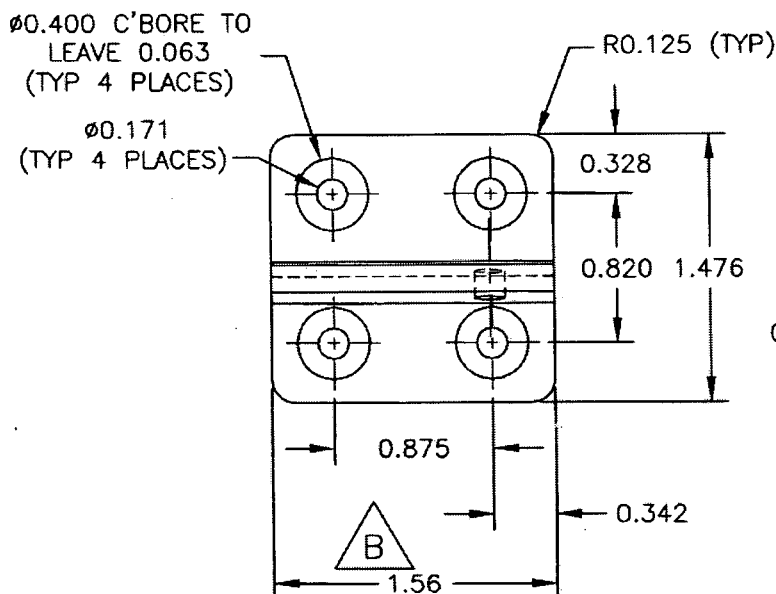
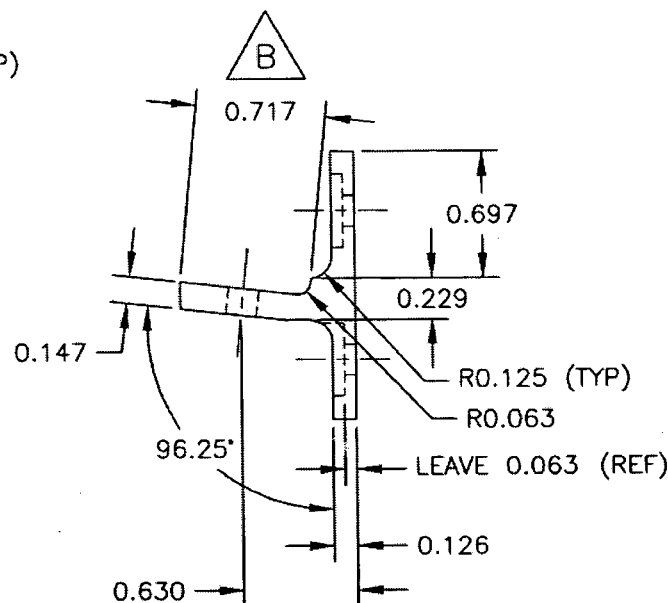
Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	

DART



RELEASED
99.07.03 KE

DESIGN	DATE	CHECKED	APPROVED	DRAWN BY	TITLE	DRAWING NO.	REV. B
VE	99.02.28	CP	KE	KE	HINGE BRACKET	D2858	SHEET 1 OF 1
A	98.12.14				NEW ISSUE		
B	99.02.28				HINGE BRACKET	0.717 WAS 0.667, 1.56 WAS 1.559	



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 26030
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY